

Work Order ID 65631

January 20, 2011 11:52:57 AM



Page 1

Item ID: D3910-1

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 1/20/11 Start Qty: 30.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 1/10/20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3910	B								

100 0.00



Bandsaw

Memo

0.00

Scapa Bandsaw

CUT BLANK 1.450" LONG

cut @ metro

110 0.00



HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA865 AND DWG
FOLIO REV: _____
DWG REV: _____

CL 1/10/20 (30)

Purchasing

DEBURR Issue P10: B326 to metro

Machine as per dwg D3910 REV.B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Stop



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Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 30.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC
Quality Control

QC2 - inspect parts off machine FAI/FAIB

0.00

Memo

0.00

rec'd + inspect of air transit damage.

1/21/11 (30)

130



QC
Quality Control

QC2 - inspect parts - second check

0.00

Memo

0.00

8/10/10

count
(730)

140



HandFinish
Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

0.00

=7

30 0 11/02/10

W/O:		WORK ORDER CHANGES					
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Work Order ID 65631

January 20, 2011 11:52:58 AM



Page 4

Item ID: D3910-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug

Start Date: 1/20/11 Start Qty: 30.00



Cust Item ID:

Required Date: 2/04/11 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/08
MF
11-02-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

January 20, 2011 11:52:56 AM

Page 1

Work Order ID: 65631



Parent Item: D3910-1



Parent Item Name: Crosstube Lug

Start Date: 1/20/11

Required Date: 2/04/11

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD IPP
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No			100	f	534.1914	0.13	4.105263			
-------	--	--------------	----	--	--	-----	---	----------	------	----------	--	--	--



Lug Extrusion



CL 1/10/120

Location

Loc Qty

Loc Code

MAT06

534.1914265

43722

180

45800

66.1914265

63005

288

4.11

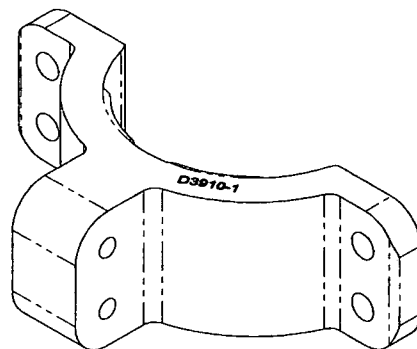
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

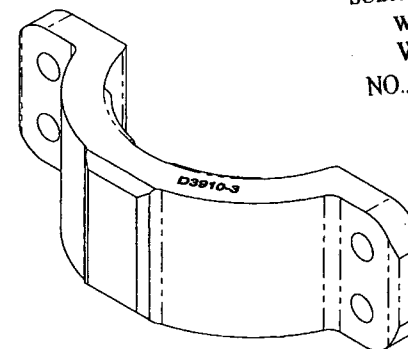
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NOTE: Date & initial all entries



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 65631
C211/01/20

RELEASED
2010-03-22
NAP

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3) REASON: SEE TR-D350-807-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3910		SHEET 1 OF 3
APPROVED		TITLE	SCALE	
DE APPR.		X-TUBE LUG (350)	NTS	
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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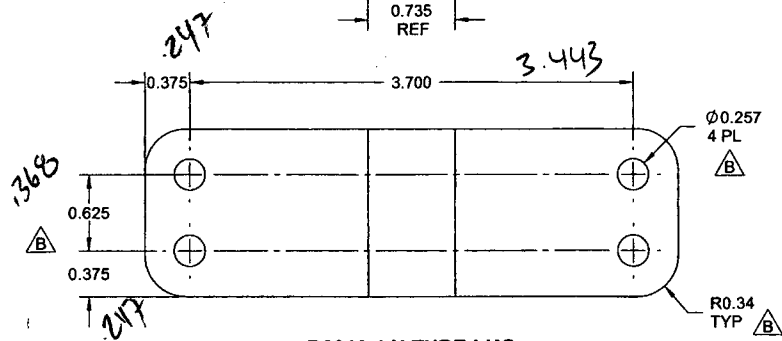
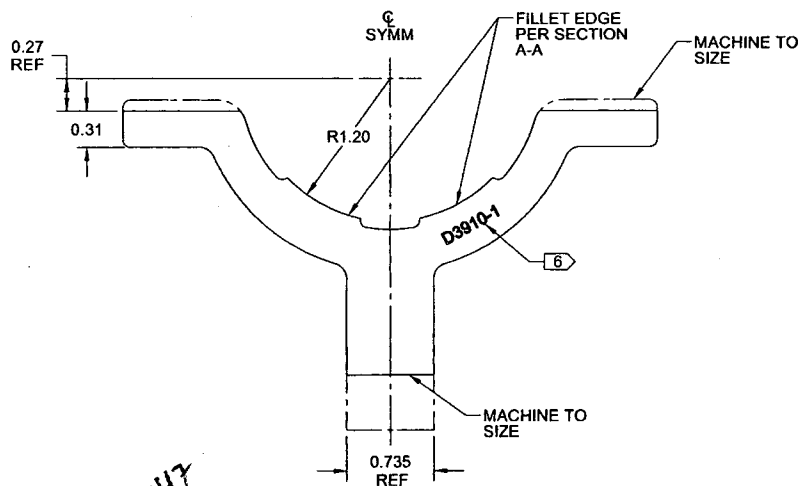
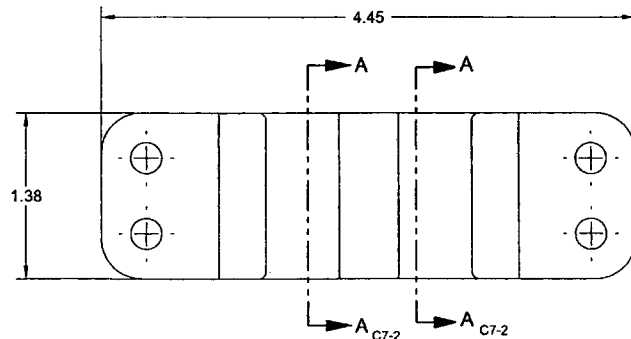
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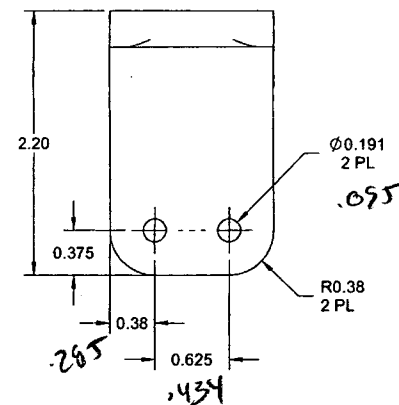
ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
C4-2
CS-2



D3910-1 X-TUBE LUG

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WITHOUT NOTICE
WORK ORDER
NO. 65631



RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JS	DRAWING NO. D3910	REV. B
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE X-TUBE LUG (350)	SCALE NTS
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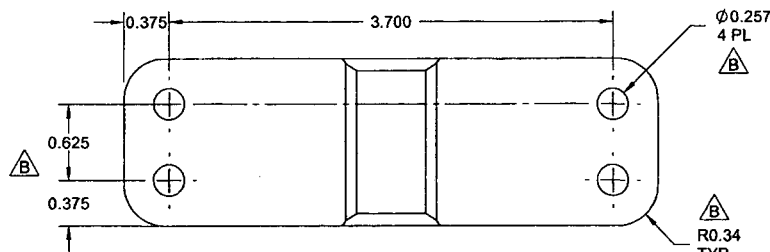
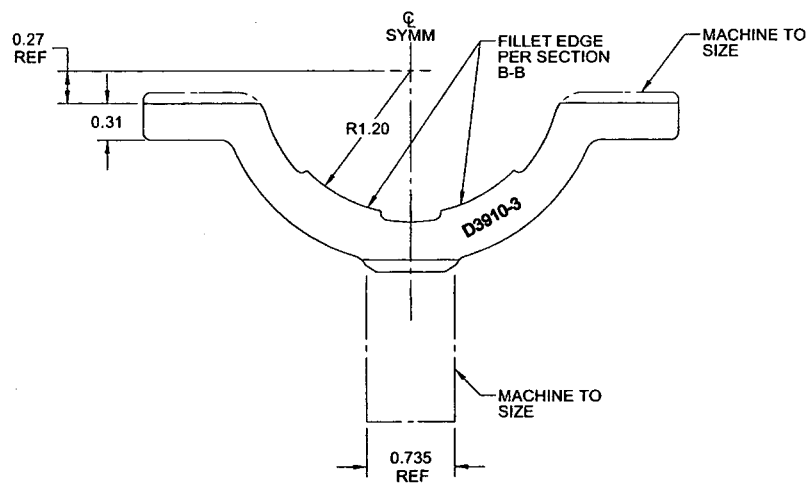
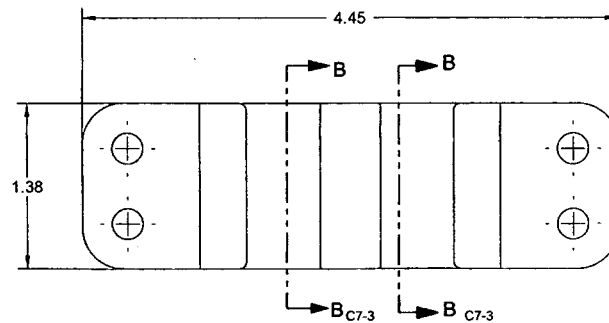
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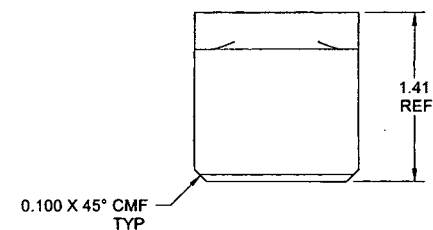
ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B
C4-3
C5-3



D3910-3 X-TUBE LUG

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2010-03-22

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CHECKED		DRAWING NO.	REV. B
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APPROVED		TITLE	SCALE
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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO13326

Purchase Order Date 1/20/11

PO Print Date 1/21/11

Page Number 1 of 2

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

REVISED

Contact Name
Vendor Phone 613 678 3957
Vendor Fax 613 678 3956
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED
FC 11/10/11

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3910-3P CXL11/01/12 rev 18	Crosstube Lug	1/28/11 Yes	30.00 Each	Yours ppd Ntc 12	\$31.5500	\$946.50
		Special Inst:	MACHINE AS PER DWG D3910 REV. B B64783				
2	D3910-1P	CROSSTUBE LUG	1/28/11 Yes	30.00 Each	Yours ppd	\$31.5500	\$946.50
		Special Inst:	MACHINE AS PER DWG D3910 REV. B B65631				
3	D4091-1P	LUG	1/28/11 Yes	24.00 Each	Yours ppd	\$20.0000	\$480.00
		Special Inst:	MACHINE AS PER DWG D4091 REV. A B65626				
4	D3041-1P	Clamp	1/28/11 Yes	20.00 Each	Yours ppd	\$31.0000	\$620.00

1/21/11



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17749

Date: Jan 31, 2011 Feb 4, 11
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13326	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
3910-3 Crosstube Lug	Each	30	12	
D3910-1 Crosstube Lug	Each	30	30	
D4091-1 Lug as per drawing D4091 Rev.A	Each	24		24
D3041-1 Clamp	Each	20		20
D3041-3 Clamp	Each	20		20
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
12	D3910-3	Crosstube Lug	13326
30	D3910-1	X-Tube Lug	13326

MATERIAL: supplied by DART D2423 B45800

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Signature

Signature
Shigi Walz

Vankleek Hill, February 4, 2011